

Work Order ID 100601 *2*

April-24-13 9:49:16 AM

100601

RUSH

16

Page 1

Item ID: D4543 6

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Outer, RH

Start Date: 4/24/13 Start Qty: 30.00 *8*

30

Required Date: 5/08/13 Req'd Qty: 30.00

30

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *ML5*

Date: *13-04-24*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4543

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

6061 TG .032

Memo

1- Cut D4543-5F as per dwg

Prog rev: *B*

Dwg rev: *B*

2- Deburr

0.00

30

DAS 05 13-04-25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

30

DAS 05 13-04-25

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Page 2

Item ID: D4543-6

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Retainer, Outer, RH

Start Date: 4/24/13 Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/08/13 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

130

Small Fab

Memo

0.00

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

0.00

Quality Control

Memo

Checked
against
template.

OK GP
13/4/28

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Page 3

Item ID: D4543-6

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Retainer, Outer, RH

Start Date: 4/24/13 Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/08/13 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

8

13.428

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

13.429

8

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

58528

13.428

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Page 4

Item ID: D4543-6

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Retainer, Outer. RH

Start Date: 4/24/13 Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/08/13 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/5/6 JF
mf
13-4-30

Picklist Print

April-24-13 9:49:20 AM

Page 1

Work Order ID: 100601

100601

Parent Item: D4543-6

D4543-6

Parent Item Name: Retainer, Outer, RII

Start Date: 4/24/13

Required Date: 5/08/13

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 13.04.23 as per dwg revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	1,183.770	2	63.15789			
M6061T6S 032										**			
6061-T6 Sheet 0.032"													

13.04.25

Location

Loc Qty

Loc Code

MAT021

1183.77

121099

171.94

122256

46.78

122737

44.8

123097

71.9

123135

37.7

123137

51.85

123293

58.5

123483

260.6

123701

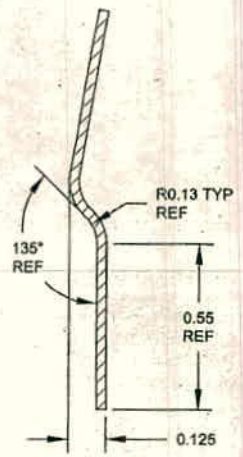
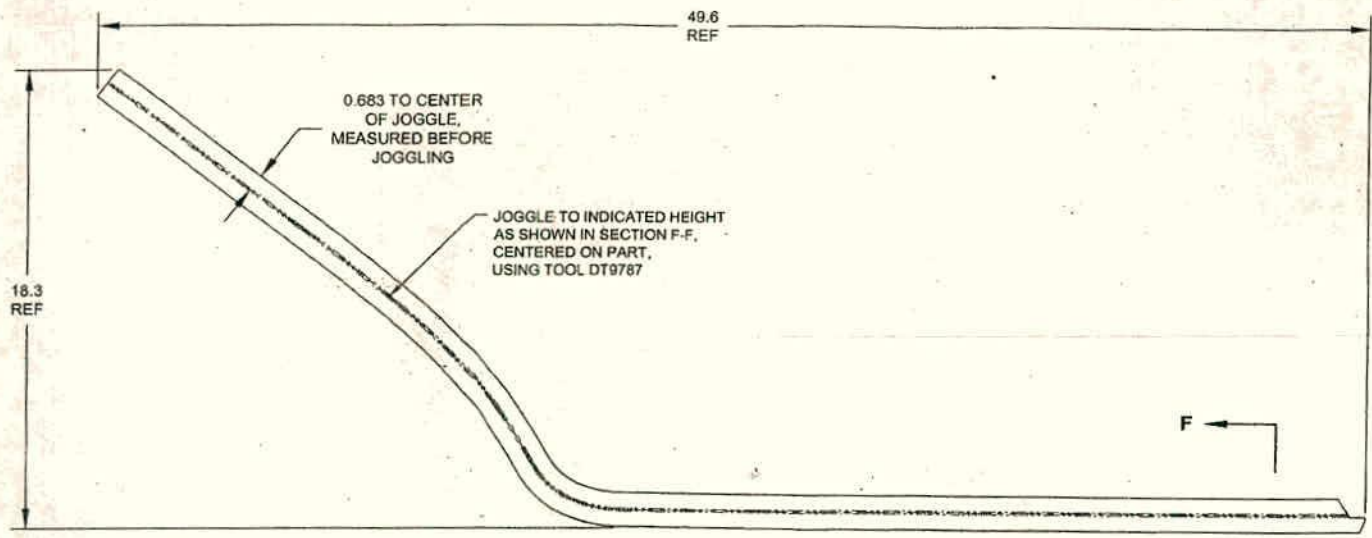
47.85

124629

199.85

125341

192



D4543-6 RETAINER, RH OUTER
(SIDE/TOP) B

SECTION F-F
JOGGLE DETAIL
SCALE 12X

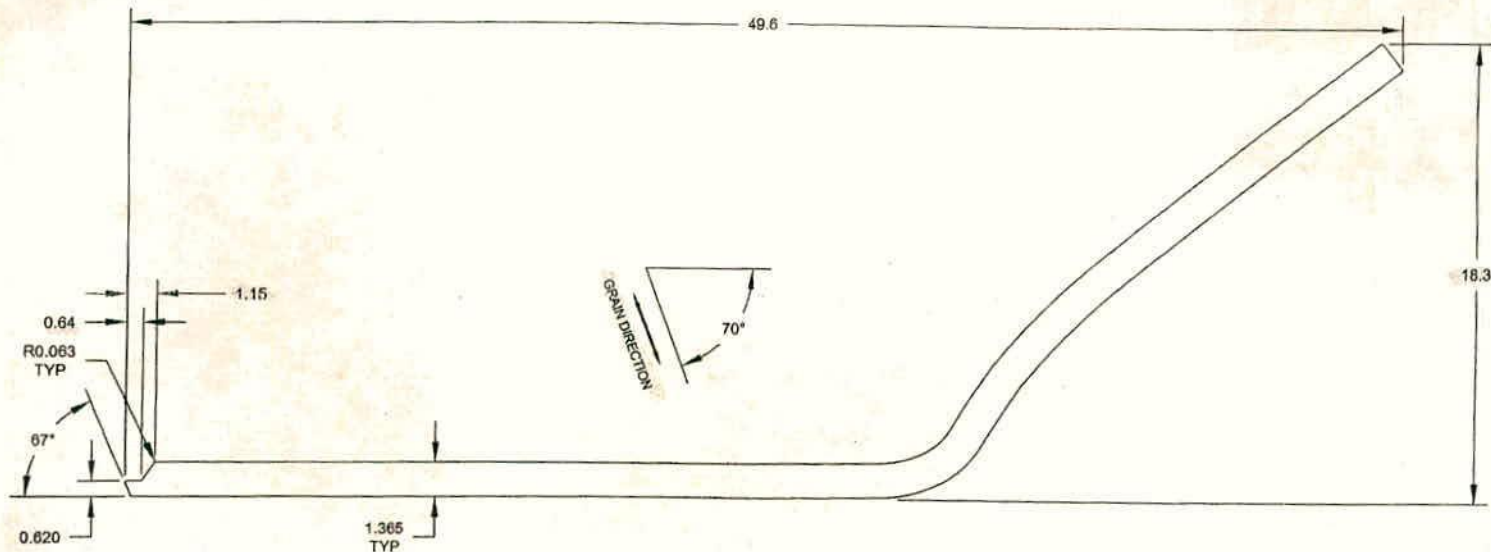
RELEASED
2013-04-22

- NOTES:**
- 1) MATERIAL: MAKE FROM D4543-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 0.24 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4543	REV. B
MFG. APPR.			SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, OUTER	NTS
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100600 MLS
13-04-24

100601



D4543-5F FLAT PATTERN



RELEASED
2013-04-22

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4026 OR AMS 4027 OR ASTM B209
REF DART SPEC. M8061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-5F-REV-B.DXF"

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4543	SHEET 9 OF 9
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